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RB23007615-21
Job Sheet 187546



Part No: RB23007615-21

Job Qty: 1 ea

Part Name: Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/7/18

Job Tracking No:

Due Date: 12/11/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/11/18	12/11/18	0.00	0.00	Start Up Machining-3		18-12-10
120	CNC Lathe	1 pcs	12/11/18	12/11/18	0.30	0.33	SL2500Y		18-12-10
130	QC	1 pcs	12/11/18	12/11/18	0.00	0.00	QC2 Machining-4		18-12-10
140	QC	1 pcs	12/11/18	12/11/18	0.00	0.00	QC8 Machining-4		18-12-12
170	Outsource	1 pcs	12/11/18	12/11/18			ATC001-VC	10	
180	Packaging	1 pcs	12/11/18	12/11/18	0.00	0.00	Packaging2		NOT REQ.
190	QC	1 pcs	12/11/18	12/11/18	0.00	0.00	QC6		
200	Packaging	1 pcs	12/11/18	12/11/18	0.00	0.00	Packaging3-1		
210	QC21-SA	1 Ea	12/11/18	12/11/18	0.00	0.00	QC21		DEC 12 2018

Part Op 120 - 1-Machine as per folio FC033 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 170 - -Issue P/O to ATG: _____ ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water
sealant - Certificate of Conformity is required ONDT ANODIZE ON - 21 mla DEC 7/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R2.000	6061T6 Round Bar 2.00	.0980 ft (.098 ea)	90-Start up Operation	M127682

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R2.000	0	6	0



Container No: S136346



Part: RB23007615-21

Job No: 187546

Serial No/Batch: S136346

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 12/10/18

ations

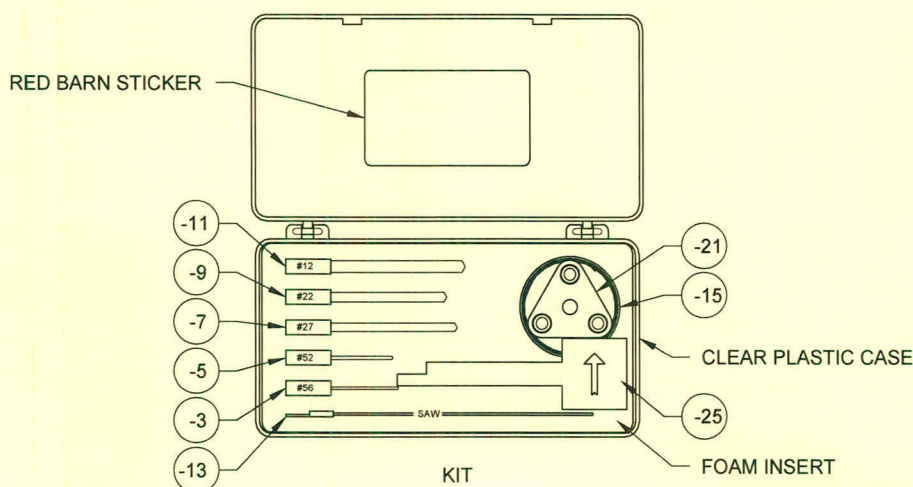
not be found.

Plex 12/7/18 11:32 AM dart.lacelle.linda

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D TITLE BLOCK & REVISION BLOCK, ADDED DWG'S FOR CASE, FOAM INSERT, & ASSY.	8/11/09	RJC	RW
B	-2 ADDED NOTES TO SHEET -13, -21, -23 MOVED TO SEPARATE SHEETS. -13 CHD DIMS WAS 6.000 IS 6.00, WAS 12.000 IS 12.00. -21 CHD DIMS WAS R.300 X3 IS 3X R.30, WAS DRILL & TAP 1/4-28 UNF X3 IS 3X 1/4-28 THRU. ADDED MISSING DIM 2X .344.	2/3/14	DPD	RJC

TEO ATTACHED



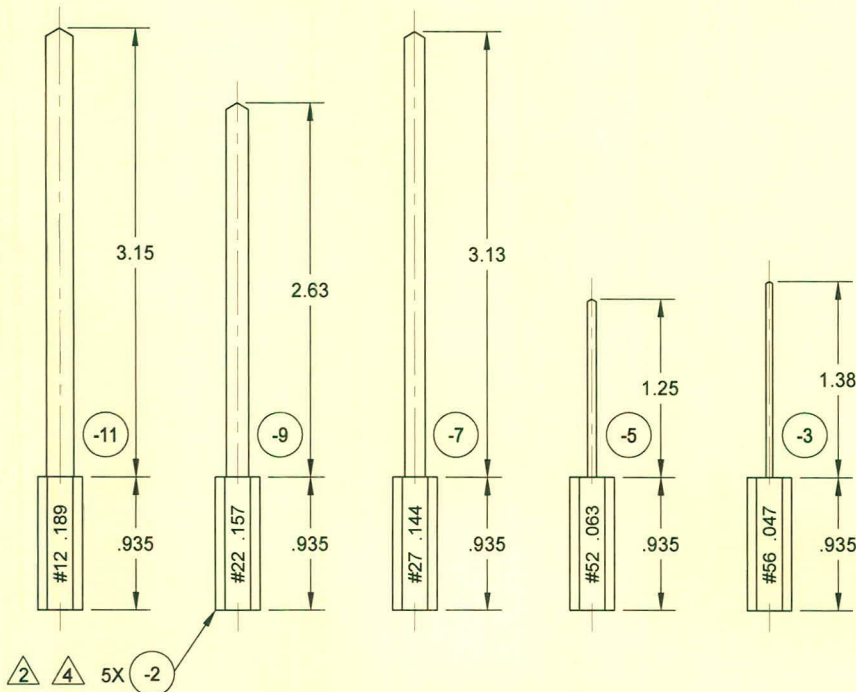
ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-2	5	BLOCK	6061	5/16 HEX x 1	2
			-3	1	#56 DRILL BIT		SEE -2 -56 FOR BLOCK METHODS	2
			-5	1	#52 DRILL BIT		SEE -2 -52 FOR BLOCK METHODS	2
			-7	1	#27 DRILL BIT		SEE -2 -27 FOR BLOCK METHODS	2
			-9	1	#22 DRILL BIT		SEE -2 -22 FOR BLOCK METHODS	2
			-11	1	#12 DRILL BIT		SEE -2 -12 FOR BLOCK METHODS	2
			-13	1	SAW		6" LENGTH #HAC5012BX (BESTWAY PRODUCTS)	3
							.050 ROUND x 6 SECTION	
		B/O	-15	4'	WIRE		.041 WRAPPED AROUND 1-7/8 ARBOR	1
			-21	1	GUIDE	6061	Ø2 x 1-1/16	4
			-23	3	SOCKET HEAD CAP SCREWS	STEEL	1/4-28 UNF x 3/8 MODIFIED MCMaster-CARR #91251A435	5
			-25	1	STRUT CHECKING GAGE	6061	.05 x 4-7/8 x 1-1/2	6
		B/O		1	CLEAR PLASTIC CASE		FLAMBEAU #K206 OR EQUIV.	7
		B/O		1	CRAFT FOAM		1 x 4 x 8	7
		B/O		1	RED BARN STICKER		STICKER FACE INSIDE LID FACING OUT	7

TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:3	DATE 2-1-01
SHEET 1 of 7	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
B	-2 ADDED NOTES TO SHEET.	2/3/14	DPD RJC

TEO ATTACHED



NOTES:

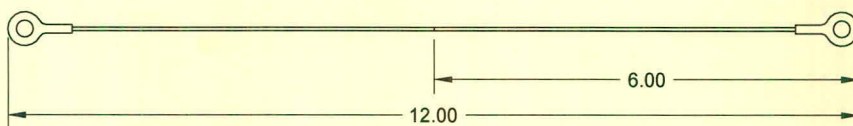
- CHECK EACH HOLE FOR PROPER EXPOSED DRILL LENGTH.
- 2 TO BE DRILLED FOR BIT TO ACHIEVE EXPOSED DRILL LENGTH.
- EPOXY BIT INTO -2 AFTER ANODIZING.
- ANODIZE BLACK MIL-A-8625F, TYPE II, CLASS II

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-2 THRU -11	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
XXX ± .005	ANGLES ± 5°
XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR 015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 2-1-01
SHEET 2 of 7	
DRAWN BY: COLE	
APPROVED <i>D. Med</i>	
HEAT TREAT FINISH SPEC SEE NOTE 4	
USED ON MODEL ALLISON C30	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	-13 MOVED TO SEPARATE SHEET. CH'D DIMS WAS 6.000 IS 6.00, WAS 12.000 IS 12.00	2/3/14	DPD	RJC

TEO ATTACHED



NOTE:
CUT EACH HAC5012BX IN HALF EACH
HAC5012BX MAKES SAWS FOR 2 KITS.

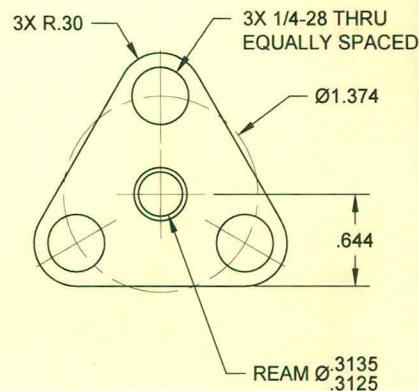
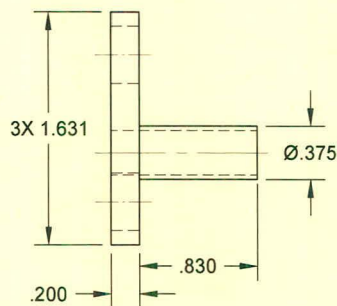
-13
SAW

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-13	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: COLE APPROVED: <i>D. Med</i> HEAT TREAT: FRESH SPEC USED ON MODEL: ALLISON C30	
SCALE 1:2	DATE 2-1-01
SHEET 3 of 7	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	-21 ADDED TO SEPARATE SHEET. CH'D DIM TOLERANCE WAS R.300 IS R.30. ADDED NOTE 3X 1/4-28 THRU EQUALLY SPACED. ADDED MISSING DIM .644.	2/3/14	DPD	RJC

TEO ATTACHED



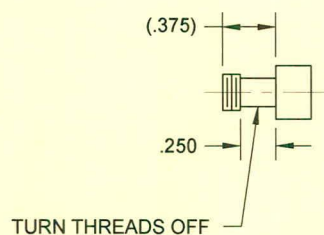
-21
GUIDE

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-21	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: COLE APPROVED: <i>D. Wed</i> HEAT TREAT: ANODIZE BLACK SPEC: MIL-A-8625F, TYPE II, CLASS II USED ON MODEL: ALLISON C30	SCALE: 1:1 DATE: 2-1-01 SHEET: 4 of 7

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
B	-23 ADDED TO SEPARATE SHEET.	2/3/14	DPD RW

TEO ATTACHED



-23

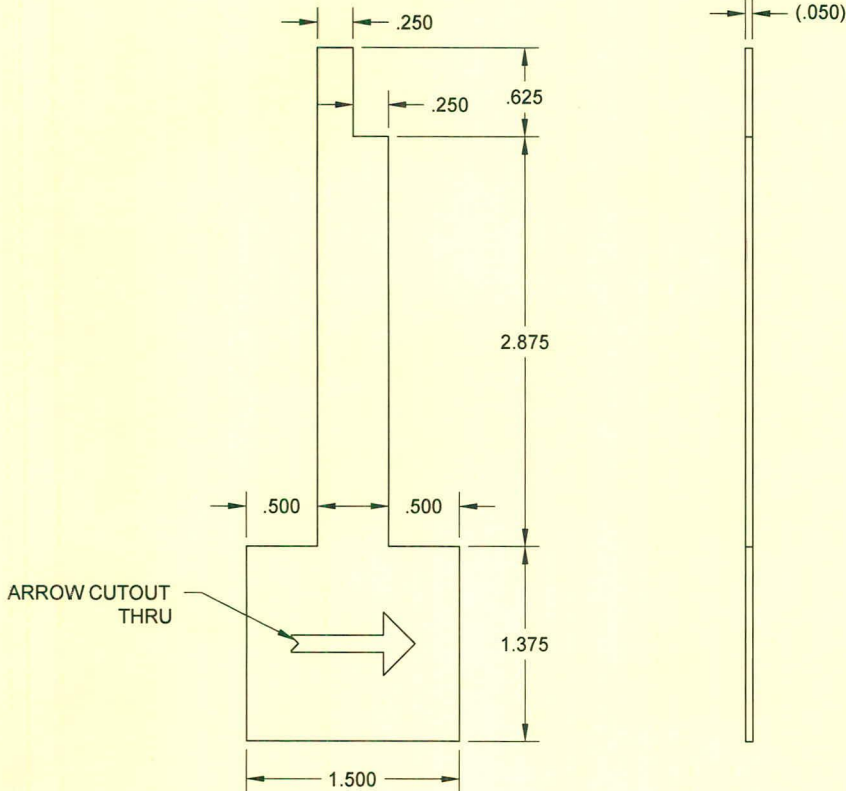
MOUNT SCREWS

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-23	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
XXX ± .005	ANGLES ± 5°
XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 2-1-01
SHEET 5 of 7	
DRAWN BY: COLE	
APPROVED: <i>D. Wood</i>	
TREAT TREAT FINISH	
BLACK OXIDE	
SPEC	
USED ON MODEL	
ALLISON C30	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
B	-25 ADDED WATERJET DXF FILE.	2/3/14	DPD RW

TEO ATTACHED



STRUT CHECKING GAGE

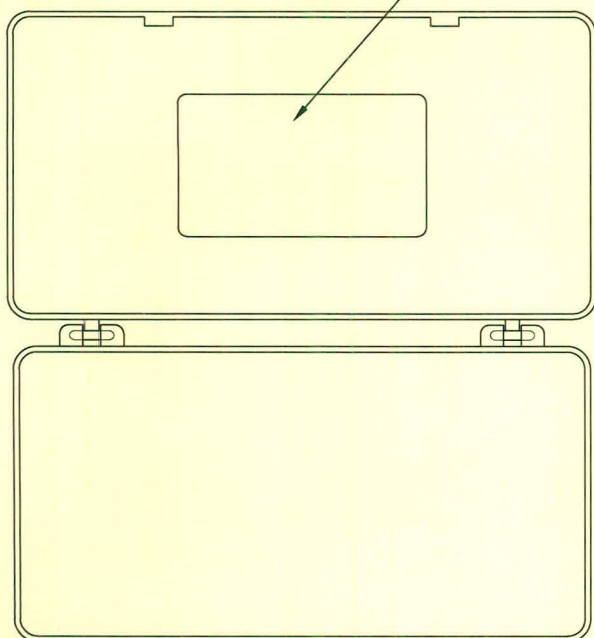
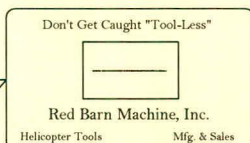
RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-25	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: COLE	APPROVED: <i>D. Ward</i>
HEAT TREAT: ANODIZE RED	SPEC: MIL-A-8625F TYPE II CLASS II
USED ON MODEL ALLISON C30	
SCALE 1:1	DATE 2-1-01
SHEET 6 of 7	

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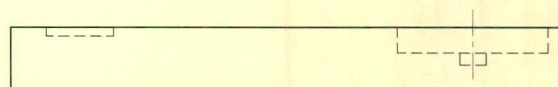
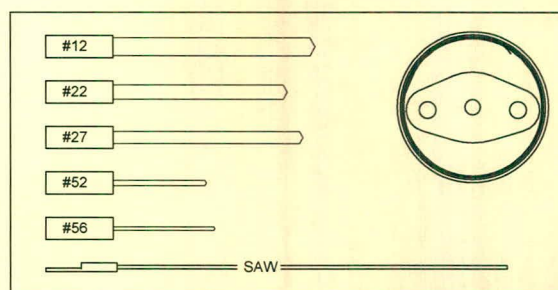
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
A	CH'D TITLE BLOCK & REVISION BLOCK, ADDED DWG'S FOR CASE, FOAM INSERT, & ASSY.	8/11/09	RJC RW

TEO ATTACHED

PLACE STICKER ON INSIDE
FACING OUT



CLEAR PLASTIC CASE



FOAM INSERT

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615 CASE & INSERT	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 2-1-01
SHEET 7 of 7	
DRAWN BY: CLOUGH APPROVED: <i>D. Med</i> USED ON MODEL ALLISON C30	



ENGINEERING ORDER # TEO17-646

SCALE: NTS

SHEET 1 OF 1

DRAWING NO. RB23007615

REV: B

EFF.: NEXT ORDER

CHANGE CATEGORY

TITLE: POWER TURBINE CLEANING KIT

☐ MAJOR ☒ MINOR

DATE 17.09.08

APPROVED: WM 10/03/2017

MFG. APPR.: DP 09/28/2017

CHECKED: SAC 09/28/2017

DRAWN: VM 09/28/2017

TRANSACTION CODE (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: EPOXY DETAILS MISSING

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USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION
FROM DART AEROSPACE LTD.

WAS : PART# RB23007615-2 THRU -11 Rev B NOTE 3 : EPOXY BIT INTO -2 AFTER ANODIZING

IS : PART# RB23007615-2 THRU -11 Rev B NOTE 3 : LOCTITE CLEAR MULTIPURPOSE INTO -2 AFTER ANODIZING

EE17-646

DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☒ BOM

